

Work Order ID 124740

Monday, September 22, 2014 3:28:31 PM

649.4901
B124740
REV. A

124740

Page 1

Item ID: 649.4901

Revision ID:

Item Name: Upper Cutter Assy

Start Date: 9/22/2014 Start Qty: 2.00

Required Date: 9/22/2014 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: 14-09-22 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
649.4900	A								
110	Pick Kit	0.00							DAS 41 9-89
110						2			15-1-12
Packaging	Memo	0.00							
Packaging									
120		0.00							DAS 41 9-89
120						2			15-1-12
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg Assemble as per dwg Apply RTV TO ALL FAYING SURFACES RTV 598 BATCH: 125637 exp: 5/15								
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130						2			
QC	Memo	0.00							
Quality Control									

JAN 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 124740

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124740

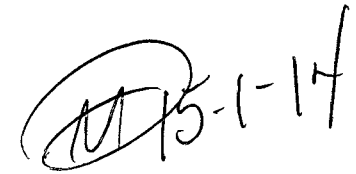
Page 2

Item ID: 649.4901 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Cutter Assy
 Start Date: 9/22/2014 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/22/2014 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CC1K25</u>	0.00				2			
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
35
9-89 JAN 14 2015

MLJ 1501-14


DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
Equip/Tooling									
Handling/Pre									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Monday, September 22, 2014 3:28:34 PM

124740

649 4901

Required Qty: 2.00

[illegible]

6

**DAS
41
9-89**

552

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
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Picklist Print

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Page 2

Work Order ID: 124740

124740

Parent Item: 649.4901

649 4901

Parent Item Name: Upper Cutter Assy

Start Date: 9/22/2014

Required Date: 9/22/2014

Start Qty: 2.00

Required Qty: 2.00

NAS1149FN832P

Purchased

No

110

Each

8,280.000

6

12

DAS

NAS1149FN832P

41

9-89

15-1-12

Washer

Location

Loc Qty

Loc Code

ST275

5775

123185

30

123522

400

123900

2

125268

5343

ST294

2505

M130388

2505

12

MS21042L08

Purchased

No

110

Each

3,365.000

3

6

DAS

MS21042L08

41

9-89

15-1-12

Nut

Location

Loc Qty

Loc Code

ST306

3365

123900

1

125445

268

m127304

99

m127410

628

m128401

1500

m128429

69

m129541

200

m130325

600

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. <u>200</u> <u>12</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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FAULT CATEGORY

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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03526

SHEET 1 OF 1

DWG NO. 649.4900

REV: A

PREPARED BY

S. COCHRAN

DATE: 05-29-12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

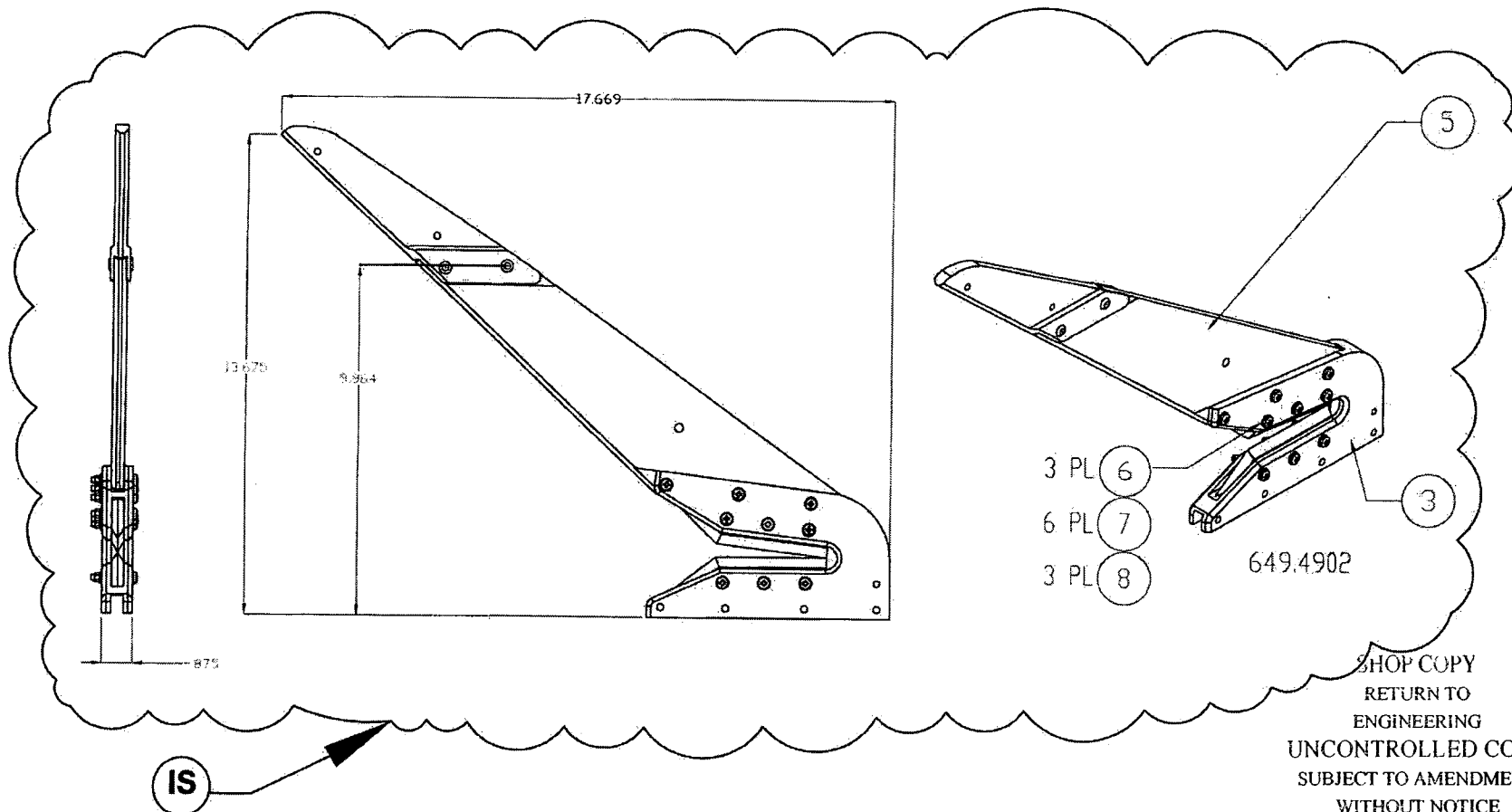
EFF:

CURRENT STOCK & NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED INSPECTION DIMENSIONS

SHEET 1, ZONE D2 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124740 MWS

14-09-22

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

DQA: _____ Date: _____



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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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1. IDENTIFY IAW MPP-120.

UNINCORPORATED ECN(S)

03524

18.046

$\cdot .875$

4.178

← 7.026 →

7.976

21.652

-.875

11.792

- 12.548

3 PL (6

6 PL 7

3 PL 8

649.4902

5

(3)

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		N/A
N/C	INITIAL RELEASE	12-07-11	P. BRAVO
A	INCORPORATED SCHOLAR & JUDGE	04-17-2012	P. BRAVO

649.4901

6 3 PL

7 6 PL

(8) 3 PL

3	3	8	601.1541	LOCKNUT		MS21042L08	
6	6	7	601.2764	WASHER		NAS1149NB32P	
3	3	6	601.2765	SCREW		MS27039-0B19	
1		5	649.5301	LOWER DEFLECTOR ASSY			
	1	4	649.5311	UPPER DEFLECTOR			
1	1	3	649.8301	CUTTER SUB ASSY			
X		2	649.4902	LOWER CUTTER ASSY			
X	X	1	649.4901	UPPER CUTTER ASSY			
4902	4901	FIND #	PART #	DESCRIPTION		MAT'L	SPEC
QTY				PARTS LIST			
NEXT ASSY [S]				APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
				CUTTER ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES .5°				REV. C		REV. A	
DRAWING APPROVAL P. BRAVO 06/10/2012				DATE		REV.	
CONTRACT NO.				SCALE NONE		SHEET 1 OF 4	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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FAULT CATEGORY

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